

**Work Order ID 67085**

Monday, March 07, 2011 3:53:07 PM



Page 1

Item ID: DSI 9396-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Crosstube Support Change

Start Date: 3/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*MF*Date: *11-03-07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9396

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP DSI 9396 CHG001

*8u103/08**Pick kit**CL 11-03-08**11/3/8 SP*

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8u103/08**CL*

120

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9396

Location: *20* ☐ PPP Rev: *Draft**11/3/8 SP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67085**

Monday, March 07, 2011 3:53:07 PM



Page 2

Item ID: DSI 9396-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Crosstube Support Change

Start Date: 3/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/08

ME

11-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, March 07, 2011 3:53:05 PM

Page 1

Work Order ID: 67085

Parent Item: DSI 9396-013

Parent Item Name: Aft Crosstube Support Change

Start Date: 3/8/2011

Required Date: 3/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-01-10 ECN 1075 DD  
IPP Rev:B 08-01-28 ECN 1108 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3595-063-530 RUBBER CUSHION		Manufactured	No			110	Each	77.0000	4	4		11/3/85	

Location	Loc Qty	Loc Code
FP	30	
50030	12	
51776	18	
LG	47	
59581	13	
63407	34	

MS21920-28

Purchased

No

120

Each

98.0000

4

4

11/3/85

Clamp(per MIL-DTL-8783C)

Location	Loc Qty	Loc Code
FG	5	
105884	5	
LG	93	
114749	6	
116039	36	
116839	51	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 Rev. C (AND EARLIER) AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 Rev. C (AND EARLIER) REF. CANADIAN STC: SH03-6 REF. FAA STC: SR01742NY

For D205-596-101/-103 Crosstubes (ref. 39" Landing Gear) or D205-596-105/-107 Crosstubes (ref. 31" Landing Gear) at CHG 002 or later, the D2856-600-851/-1009 Abrasion Strips have been removed, the MS21920-25 Clamp replaces the MS21920-24 Clamps, the D2893-1 and D2940-1 Supports have been bonded onto the crosstubes using Magnobond 6398 and D3595-063-450/-530 Rubber Cushions have been installed underneath the MS21920-25/-28 Clamps. Amend Parts List of IIN-D205-594 Section 5 and ICA-D205-594 Section 32.8 as follows:

## Remove:


QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
2		2		D2856-600-851	ABRASION STRIP
	2		2	D2856-600-1009	ABRASION STRIP
4		4		MS21920-24	CLAMPS

## Add:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
4		4		D3595-063-450	RUBBER CUSHION
	4		4	D3595-063-530	RUBBER CUSHION
4		4		MS21920-25	CLAMP

To prevent the supports from shifting on D205-596-101/-103/-105/-107 Crosstubes at CHG 001, the D2893-1 or D2940-1 Supports should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D205-594 for the removal of the crosstubes from the helicopter.
- 2) Remove the MS21920-24/-28 Clamps that fasten the D2893-1 and D2940-1 Supports from the crosstubes per Section 32.3 of ICA-D205-594.
- 3) Remove the D2856-600-851/-1009 Abrasion Strips from the crosstube per section 32.5 of ICA-D205-594.
- 4) Inspect the crosstube surface underneath the supports for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.3 of the 300 hour inspection.
- 5) Inspect the supports for corrosion and mechanical damage per items 5.3.4 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.4 of the 300 hour inspection.
- 6) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- 7) Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2893-1 or D2940-1 Supports and re-install the Supports on the crosstube as shown in Figure 1. Install a D3595-063-450/-530 Rubber Cushion on each MS21920-25/-28 Clamp. Position and secure the D2893-1 or D2940-1 Supports on the crosstube using MS21920-25/-28 Clamps. Torque clamps to 80-100 in-lb. Let the D205-596-101/-103/-105/-107 Crosstube Assembly cure before re-installing the crosstube on the aircraft.  
**Note:** It is acceptable to substitute the MS21920-25/-28 with longer or shorter clamps to accommodate varying diameters. Ensure there is a minimum of 1.5 threads in safety on the nut.
- 8) Re-install the D205-596-101/-103/-105/-107 crosstube per section 32.2 of ICA-D205-594.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: 	
D. SHEPHERD (DE # 02)	
DATE: 07.12.04	
CERT. NO.: SH03-6	
ISSUE NO.: 3	

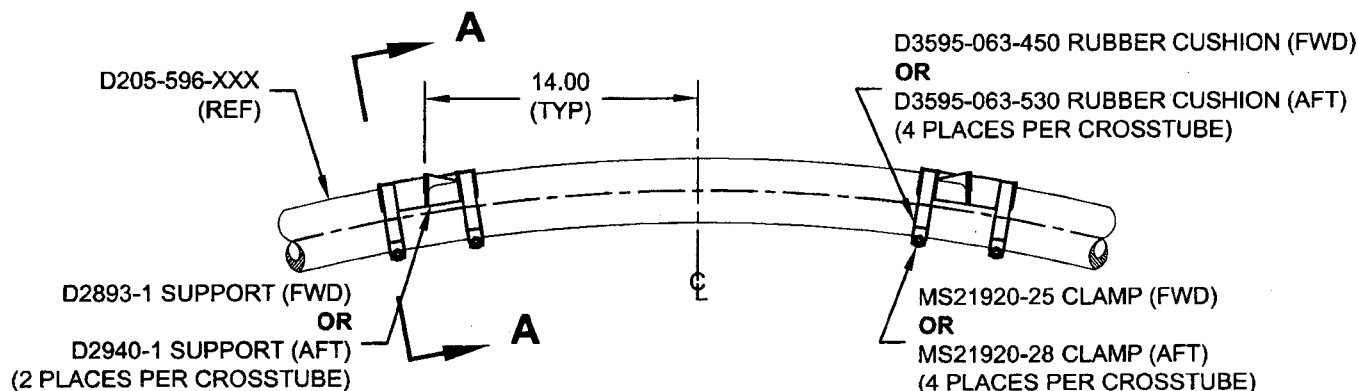
B	REPLACE MS21920-24 WITH MS21920-25 ON -101/-105; ADDED EXTRA NOTE TO INSTALLATION PROCEDURE (STEP 7)	MB	07.12.04
A	NEW ISSUE	MB	07.11.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. REV. B DSI 9396 SHEET 1 OF 2	
CHECKED		TITLE SCALE CROSSTUBE SUPPORT CHANGE NTS	
MFG. APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED			
DE APPR.			
DATE	07.12.04		

For customers who would like to upgrade their D205-596-101/-103/-105/-107 Crosstubes from CHG 001 to CHG 002, the following kits can be obtained from Dart:

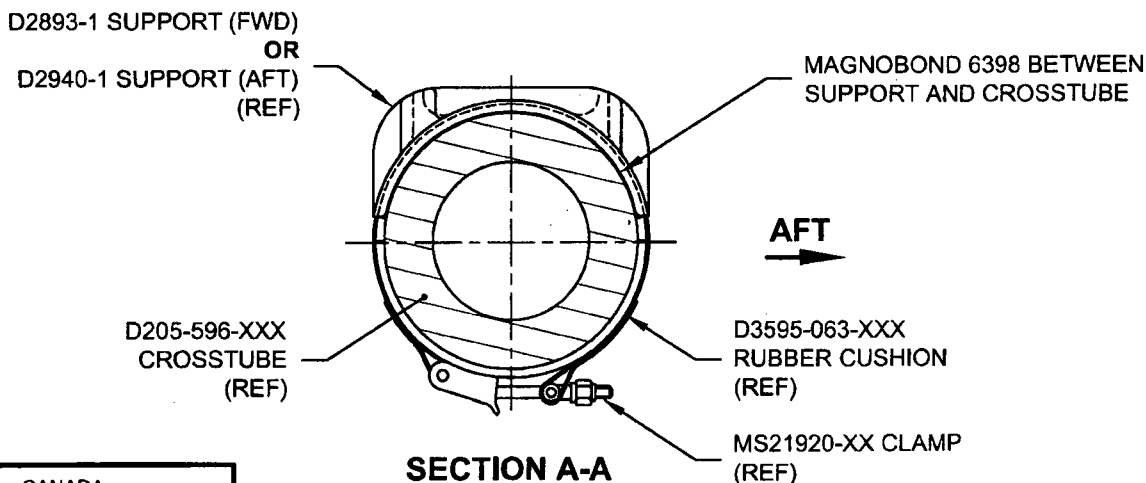
# DSI 9396-XXX PARTS LIST

QTY -011	QTY -013	Part Number	Description
X		DSI 9396-011	FWD CROSSTUBE SUPPORT CHANGE (D205-596-101/-105 FWD CROSSTUBE)
	X	DSI 9396-013	AFT CROSSTUBE SUPPORT CHANGE (D205-596-103/-107 AFT CROSSTUBE)
4		D3595-063-450	RUBBER CUSHION
4		MS21920-25	CLAMP
	4	D3595-063-530	RUBBER CUSHION
	4	MS21920-28	CLAMP

REFERENCE ONLY



**FIGURE 1: INSTALLATION OF SUPPORT ON CROSSTUBE**



CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 07.12.04  
CERT. NO.: SH03-6  
ISSUE NO.: 3

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>[Signature]</i>	
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. B
MFG. APPR.	<i>[Signature]</i>	DSI 9396 SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE SUPPORT CHANGE NTS
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